

Date: Wednesday, 6/6/2007 1:43:59 PM
 User: Kim Johnston

Process Sheet

26

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : R44 CARGO MIRROR
Job Number : 32763	
Estimate Number : 10095	
P.O. Number : <i>N/A</i>	Part Number : D044715011
This Issue : 6/6/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3243REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 30335	Material : Manufacture in multiples of 10
Written By : <i>[Signature]</i>	Due Date : 6/30/2007 Qty: 5 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est Rev:A 04.02.18 New issue KJ/JLM	
Est Rev:B 06-04-28 Manufactured on Water Jet JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPPD044-715-011 CHG001

5 7/12/10

2.0	M6061T6S063	6061-T6 .063 Sheet
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Comment: Qty.: 0.5359 sf(s)/Unit Total : 2.6796 sf(s)

Material: 6061-T6 (QQ-A-250/11) 0.063" thick(M6061T6S.063)Identify for D3244-1

Batch: *M18556**SAD 07/06/12**(5)*

3.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3243

Dwg Rev: *A*Prog Rev: *A*

2-Deburr if necessary

*MF SAD**07-06-25 07/06/12**(5) (5) (PTO)*

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*SAD**07/06/13**(5)*

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

5 07/06/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: PD Date: 07/12/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/06/13	2.0	One part was Scrap because the Jet offset had to be change to 0.017 instead of the regular offset of 0.015	<i>[Signature]</i> 07/06/13	Scrap destroy, replace	SAD 07/06/13	<i>[Signature]</i> 07/06/13	<i>[Signature]</i> 07/06/13	<i>[Signature]</i> 07/06/13

NOTE: Date & initial all entries

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Drawing Name: R44 CARGO MIRROR

Job Number: 32763

Part Number: D044715011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Bend as per Dwg D3243

SB 07/11/20

5

7.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

counter
07/11/21 (X5)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Chemical Conversion Coat as per QSI 005 4.1

FL 07/11/21 5

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

x5
ml 07/12/05

10.0

FE032EF

Inserts



Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 FE-032EF

Insert

B102973X1

M 105385 X 19

1 D3243-1(Ref)

Bracket

B 32763

ml 07/12/05

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg d3243

ml 07/12/05

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/12/05 (X5)

13.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

1-Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

M-L 07/12/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: R44 CARGO MIRROR

Job Number: 32763

Part Number: D044715011

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Handwritten: MJ



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Handwritten: 07-12-06

Handwritten: (X5)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Pick Packing Kit

16.0

D1048

Clamp



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick: Packing Kit

QtyPart Number Description Batch
2 D1048 Clamp

Handwritten: B30373

Handwritten: AS 07/12/12

Handwritten: (X5)

17.0

D1049

Saddle



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick: Packing Kit

QtyPart Number Description Batch
2 D1049 Saddle

Handwritten: B32797

Handwritten: AS 07/12/12

Handwritten: (X5)

18.0

D2010104

Mirror Arm 369/500



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Pick: Packing Kit

QtyPart Number Description Batch
1 D2010-104 Arm

Handwritten: B34672 x2 B32386 x3

Handwritten: AS 07/12/12

Handwritten: (X5)

19.0

D2011101

Mirror 6"



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Pick: Packing Kit

QtyPart Number Description Batch
1 D2011-101 Mirror

Handwritten: B32763

Handwritten: B32763

Handwritten: AS 07/12/12

Handwritten: (X5)

20.0

ALS41032130

Insert



Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick: Packing Kit

QtyPart Number Description Batch
4 ALS4-1032-130Insert

Handwritten: M105730

Handwritten: AS 07/12/12

Handwritten: (X5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: PD Date: 07/12/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 6/6/2007 1:43:59 PM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: R44 CARGO MIRROR

Job Number: 32763

Part Number: D044715011

Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

AN34A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

QtyPart Number Description Batch

4 AN3-4A

Bolt

M103641

AS 07/12/12 (X5)

22.0

AN526C1032R10

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

QtyPart Number Description Batch

4 AN526C1032R10 Screw

M15072

AS 07/12/12 (X5)

23.0

AN960JD10L

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

QtyPart Number Description Batch

4 AN960JD10L Washer

M104374

AS 07/12/12 (X5)

24.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

6 07/12/12 (X5)

25.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D044715-01.1

Location: A

6 7/12/12 (X5)

26.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

6 07/12/12 (X5)

Job Completion

in 2007/12/18
W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

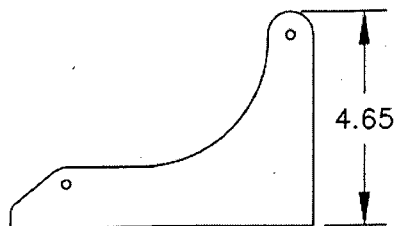
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3243	REV. A SHEET 1 OF 1
DATE 04.01.09		TITLE BRACKET	SCALE 1:2
A	04.01.09	NEW ISSUE	



R0.188 (TYP)



D3243-1 BEND DETAIL/
D3243-041 ASSEMBLY
SCALE 1:4

INSTALL
FE-032-EF INSERTS
(4 PLACES)

2.75 ± 0.030
0.000

11.920

11.420

Ø0.201
(TYP 4
PLACES)

Ø0.290
(TYP 4
PLACES)

1.375

5.273

3.714

0.500

0.000

0.750
0.500
0.000

RELEASED
04.02.03

GRAIN
DIRECTION

8.581

8.206

7.706

4.214

R0.25 (TYP)

3.339

R0.38
(TYP)

5.494

R2.75
(TYP)

D3243-1
FLAT PATTERN

R0.50
(TYP)

**D3243-041 BRACKET ASSEMBLY
(D3243-1 BRACKET)**

- 1) MATERIAL: 6061-T6, 0.063 THICK
(QQ-A-250/11, REF DART SPEC
M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT
PER DART QSI 005 4.1
POWDER COAT BLACK (4.3.5.7) PER
DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO
0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32763

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Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : R44 CARGO MIRROR
Job Number : 32763	
Estimate Number : 10095	
P.O. Number :	Part Number : D044715011
This Issue : 6/6/2007 S.O. No. :	Drawing Number : D3243REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 30335	Material : Manufacture in multiples of 10
Written By :	Due Date : 6/30/2007 Qty: 5 Um: Each
Checked & Approved By : <u>[Signature]</u>	
Comment : Est Rev:A 04.02.18 New issue KJ/JLM	
Est Rev:B 06-04-28 Manufactured on Water Jet JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPPD044-715-011 CHG001

07.08.11 [Signature]

2.0	M6061T6S063	6061-T6 .063 Sheet
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Comment: Qty.: 0.5359 sf(s)/Unit Total : 2.6796 sf(s)

Material: 6061-T6 (QQ-A-250/11) 0.063" thick(M6061T6S.063)Identify for D3244-1

Batch: _____

3.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D3243

Dwg Rev: _____

Prog Rev: _____

2-Deburr if necessary

REFERENCE ONLY

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK